



8368

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6505G00831-3G

Job Sheet 184758



Part No: RBW6505G00831-3G

Job Qty: 1 pcs

Part Name: Tail Rotor Gear Box Support Trolley Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 12/6/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBW6505G00831-3G Rev2 IPP Rev A 17.11.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/6/18	12/6/18	0.00	1.00	Small Fab - 1		
							Small Fab - 2		MLL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	12/6/18	12/6/18	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/6/18	12/6/18	0.00	0.00	QC 5 - 9		PD 19-02-28
							QC 5 - 50		
							QC 5 - 30		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S157393



Part: RBW6505G00831 - 3G

Job No: 184758

Serial No/Batch: S157393

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/28/19

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	12/6/18	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
Part Op 110 - Small Fab-8 (Small Fab) Assemble as per DWG. Sheet 1 & 2 Descriptions: 120 - QC5 (QC5- Inspect part completeness to step on W/O) 130 - Packaging3-1 (Identify as per dwg & Stock Location:_____) 140 - QC21 (QC21- Final Inspection - Work Order Release)					DAS 21 9-89 MAR 01 2019 GA062F

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	6 Ea (6 ea)	110-Small Fab	- 1
90177A219 63	Split Ring	6 Ea (6 ea)	110-Small Fab	5122137
90949A016 66	Locknut	2 Ea (2 ea)	110-Small Fab	5015388
91251A421	Socket Head Cap Screw	2 Ea (2 ea)	110-Small Fab	5015389
91251A426	Socket Head Cap Screw	2 Ea (2 ea)	110-Small Fab	5037411
91259A583	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread	2 Ea (2 ea)	110-Small Fab	5015390
91654A076	Drive Screw #2 3/16" Long	4 Ea (4 ea)	110-Small Fab	5131313
92620A540	Hex Head Cap Screw	4 Ea (4 ea)	110-Small Fab	5015391
94744A240	Flat Washer	4 Ea (4 ea)	110-Small Fab	5015392
95395A226	Washer	2 Ea (2 ea)	110-Small Fab	5131326
98099A031	Washer	2 Ea (2 ea)	110-Small Fab	5015394
CL-2-C	Lanyard Wire	2.5000 ft (2.5 ea)	110-Small Fab	5120475
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5119933
143F RBW6505G00831-3G-1	Leg Assembly Weldment	1 pcs (1 ea)	110-Small Fab	502040
98 RBW6505G00831-3G-19	Swivel Base	1 pcs (1 ea)	110-Small Fab	5131435
97 RBW6505G00831-3G-21	Swivel Plate	1 pcs (1 ea)	110-Small Fab	5088458
98 RBW6505G00831-3G-23	Bar	1 pcs (1 ea)	110-Small Fab	5080558
98 RBW6505G00831-3G-25	Mount Plate	1 pcs (1 ea)	110-Small Fab	5080855
98 RBW6505G00831-3G-41	Pin	3 pcs (3 ea)	110-Small Fab	5080869
143F RBW6505G00831-3G-7	Swivel Plate Weldment	1 pcs (1 ea)	110-Small Fab	5128407
				5132462

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3896T31	6	618	0
	90177A219	6	14	0
	90949A016	2	88	0
	91251A421	2	8	0
	91251A426	2	13	0
	91259A583	2	10	0
	91654A076	4	56	0
	92620A540	4	172	0
	94744A240	4	25	0
	95395A226	2	3	0
	98099A031	2	18	0
	CL-2-C	3	493	0
	RB41011	1	487	0
	RBW6505G00831-3G-1	1	1	0
	RBW6505G00831-3G-19	1	3	0
	RBW6505G00831-3G-21	1	1	0
	RBW6505G00831-3G-23	1	1	0
	RBW6505G00831-3G-25	1	3	0
	RBW6505G00831-3G-41	3	8	0
	RBW6505G00831-3G-7	1	1	0

Part Specifications
Specifications could not be found.

Plex 1/23/19 2:39 PM Dart.Hadley.Shannon



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q550

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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/6/18	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	1 pcs		12/6/18	0.00	1.00	Small Fab-8		
120	QC	1 pcs		12/6/18	0.00	0.00	QC5		
130	Packaging	1 pcs		12/6/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		12/6/18	0.00	0.00	QC21		

Part Op 90 - DWG needs engineering sign off for Ferrule 3896t31 and cable CL-2-C
Descriptions: 110 - Assemble as per DWG. Sheet 1 & 2

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	6 Ea (6 ea)	90-Start up Operation	
90177A219	Split Ring	6 Ea (6 ea)	90-Start up Operation	
90949A016	Locknut	2 Ea (2 ea)	90-Start up Operation	
91251A421	Socket Head Cap Screw	2 Ea (2 ea)	90-Start up Operation	
91251A426	Socket Head Cap Screw	2 Ea (2 ea)	90-Start up Operation	
91259A583	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread	2 Ea (2 ea)	90-Start up Operation	
91654A076	Drive Screw #2 3/16" Long	4 Ea (4 ea)	90-Start up Operation	
92620A540	Hex Head Cap Screw	4 Ea (4 ea)	90-Start up Operation	
94744A240	Flat Washer	4 Ea (4 ea)	90-Start up Operation	
95395A226	Washer	2 Ea (2 ea)	90-Start up Operation	
98099A031	Washer	2 Ea (2 ea)	90-Start up Operation	
CL-2-C	Lanyard Wire	2.5000 ft (2.5 ea)	90-Start up Operation	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	
RBW6505G00831-3G-1	Leg Assembly Weldment	1 Ea (1 ea)	90-Start up Operation	
RBW6505G00831-3G-19	Swivel Base	1 Ea (1 ea)	90-Start up Operation	
RBW6505G00831-3G-21	Swivel Plate	1 Ea (1 ea)	90-Start up Operation	
RBW6505G00831-3G-23	Bar	1 Ea (1 ea)	90-Start up Operation	
RBW6505G00831-3G-25	Mount Plate	1 Ea (1 ea)	90-Start up Operation	
RBW6505G00831-3G-41	Pin	3 Ea (3 ea)	90-Start up Operation	
RBW6505G00831-3G-7	Swivel Plate Weldment	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	6	710	0
	90177A219	6	32	0
	90949A016	2	94	0
	91251A421	2	14	0
	91251A426	2	19	0
	91259A583	2	6	0
	91654A076	4	79	0
	92620A540	4	188	0
	94744A240	4	13	0
	95395A226	2	9	
	98099A031	2	4	
	CL-2-C	3	37	
	RB41011	1	746	
	RBW6505G00831-3G-1	1	1	
	RBW6505G00831-3G-19	1	6	
	RBW6505G00831-3G-21	1	4	
	RBW6505G00831-3G-23	1	4	
	RBW6505G00831-3G-25	1	6	
	RBW6505G00831-3G-41	3	7	
	RBW6505G00831-3G-7	1	1	

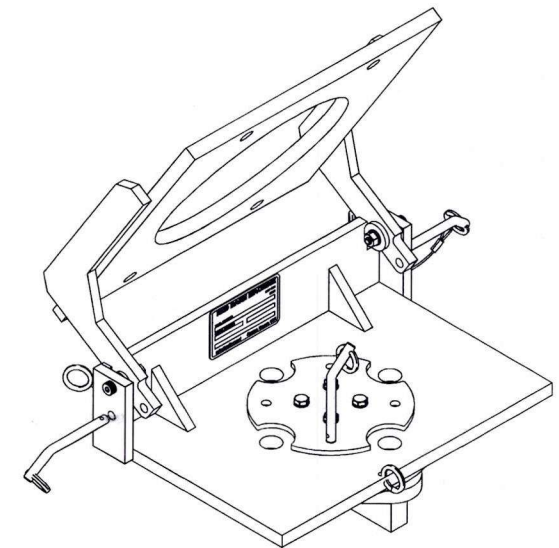
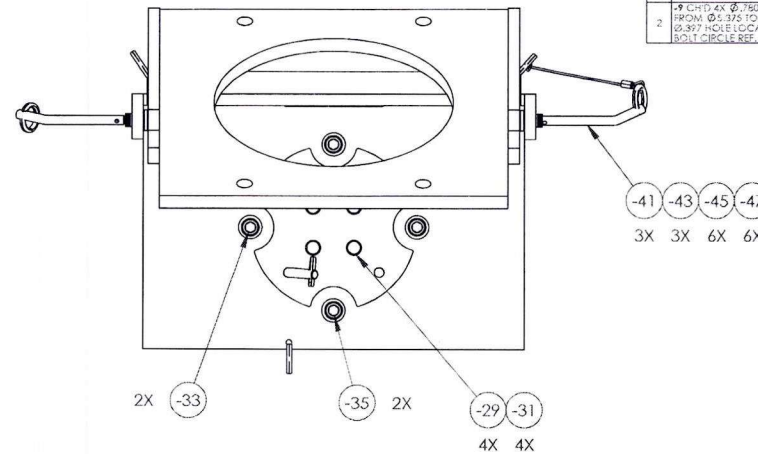
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED SHEET 16 FOR -41, SHEET 5 CHD -5 DIMENSION LOCATION WAS 4.255 IS 7.255	5/10/2013	CFS	
2	-9 CHD 4X Ø.750 HOLE 8" C. FROM Ø.5.375 TO Ø.5.512; -19 CHD COUNTER BORED HOLES 8" C. FROM Ø.5.375 TO Ø.5.512; -23 CHD HOLE LOCATIONS FROM 5.38 TO 5.51; -25 CHD 3/8-24 AND Ø.3977 HOLE LOCATIONS FROM 2X 1.70 AND 2X 3.80 TO 2X 1.95 AND 2X 3.90 AND ADDED Ø.5.512 8/11 CIRCLE REF.	7/12/2013	RJC	RW

TEO ATTACHED



SEE ATTACHED DEVIATION

 RED BARN MACHINE			
TITLE TROLLEY ADAPTER, TGB SUPPORT			
DWG NO. RBW6505G00831-3G		REV 2	
MAT'L		DRAWN BY: CLOUGH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED: <i>D. W. Smith</i>	
.XXX ± .005 FRACTIONS ± 1/32		HEAT TREAT	
.XX ± .01 ANGLES ± .5°		FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AW139	
SCALE 1:4	DATE 2/6/2012	SHEET 1 OF 16	

